

Work Order ID 83829 -

Thursday, April 26, 2012 1:08:03 PM

83829

Page 1

Item ID: D4463-041

Revision ID:

Item Name: Tank Top Assembly

Start Date: 4/26/2012 Start Qty: 4.00

Required Date: 5/3/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: *MF*Date: *12-04-28*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4463

C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

6061 . 063

1-Cut as per Dwg

Dwg Rev: *E*Prog Rev: *E*

2-Deburr if necessary

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

ASAP
2 per
1

4 *0* *5m / 12-5-3*

4 *0* *5m / 12-5-3*

(70)



Work Order ID 83829

Thursday, April 26, 2012 1:08:03 PM

83829

Page 2

Item ID: D4463-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Top Assembly

Start Date: 4/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Small Fab

NC BRAKE

Memo

0.00

0.00

Small Fab

C/SINK HOLES AS PER DWG

1X

12/05/07

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8/26/07

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

12-5-7

12-5-7

Work Order ID 83829

83829

Page 3

Thursday, April 26, 2012 1:08:03 PM

Item ID: D4463-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tank Top Assembly

Start Date: 4/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

1 / 12-05-07

170

0.00

170

Small Fab

Memo

0.00

Small Fab

INSTALL ANCHOR NUTS AS PER DWG

test

1x / 12/05/07

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

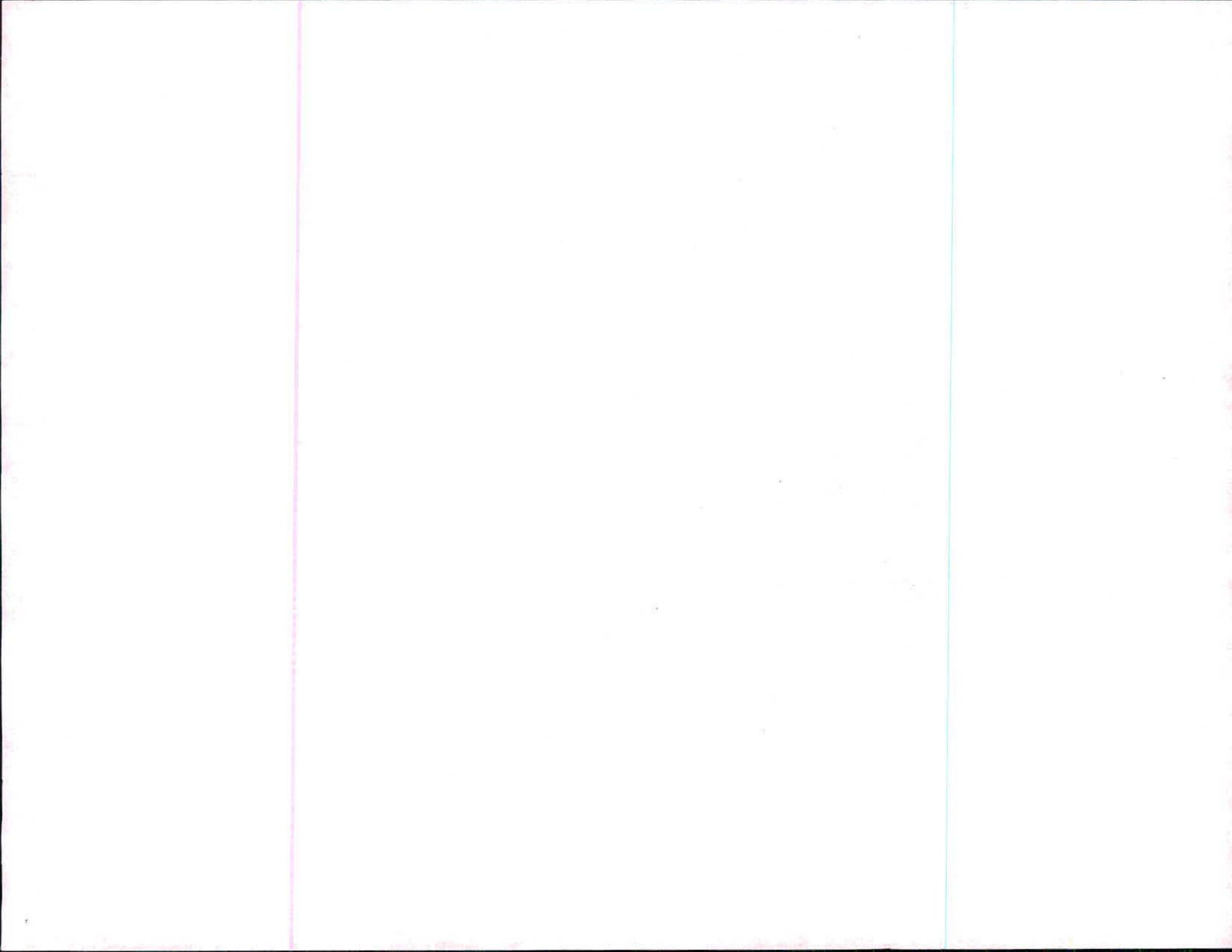
Memo

0.00

Quality Control

5/12/07

A



Work Order ID 83829

Thursday, April 26, 2012 1:08:03 PM

83829

Page 4

Item ID: D4463-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Top Assembly

Start Date: 4/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location: *WIP*

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/5/07
MF
12-05-07

Picklist Print

Thursday, April 26, 2012 1:08:02 PM

Page 1

Work Order ID: 83829
Parent Item: D4463-041
Parent Item Name: Tank Top Assembly

Start Date: 4/26/2012 Required Date: 5/3/2012
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	286.8422	3.864	15.456			

Location Loc Qty Loc Code

MAT021 286.8422000
113608 0
116308 6.01556842
117285 67.544
119331 44.2
119802 20.94
120218 21
120866 127.142632

MS20426AD3-4
RIVET

Purchased No 121578 170 Each 3,280.0000 48 192

Location Loc Qty Loc Code

ST316 3280
104374 614
110398 2666

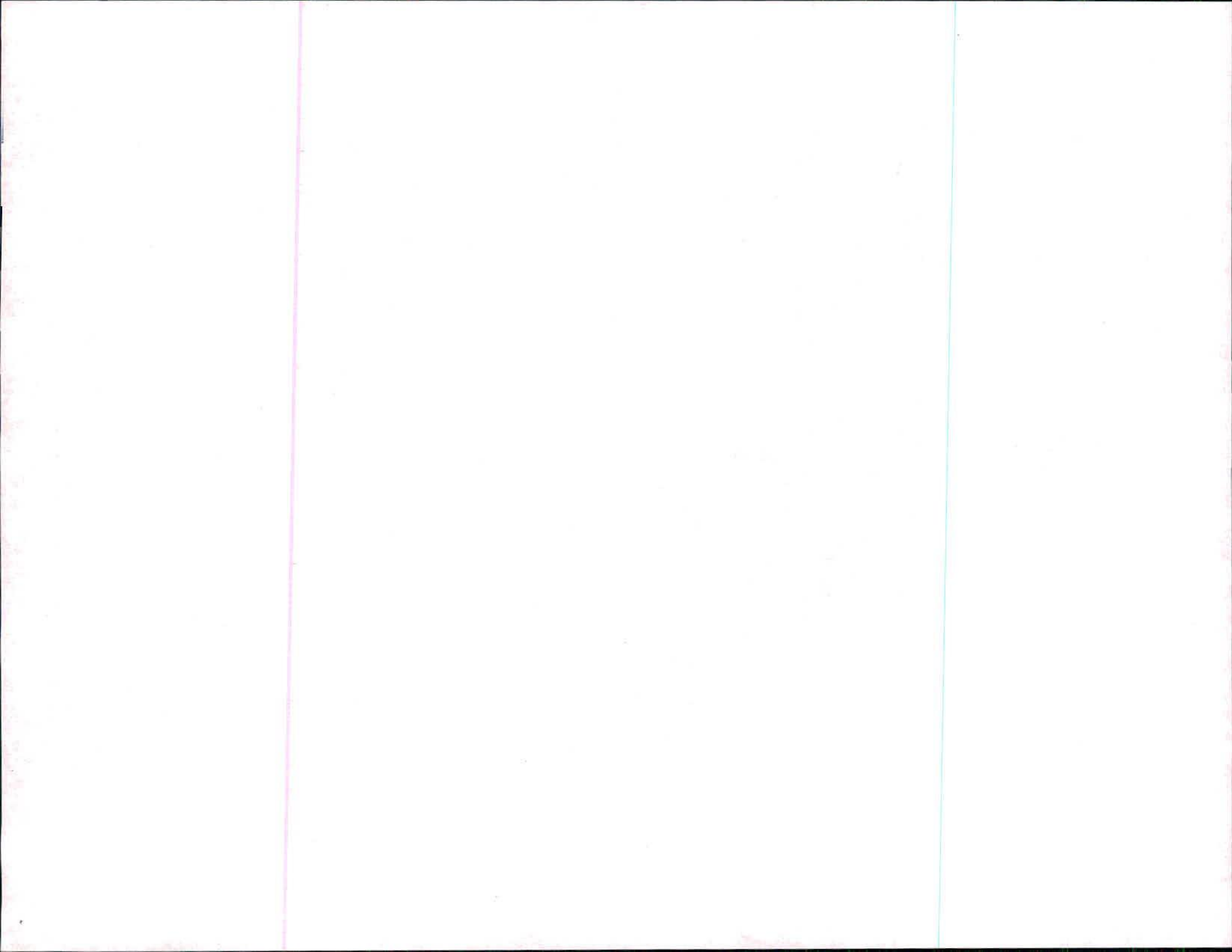
NAS1473R3
Anchor Nut

Purchased No 170 Each 84.0000 24 96

Location Loc Qty Loc Code

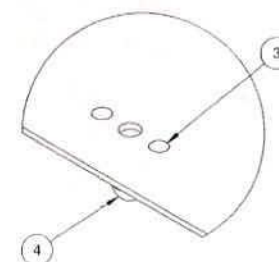
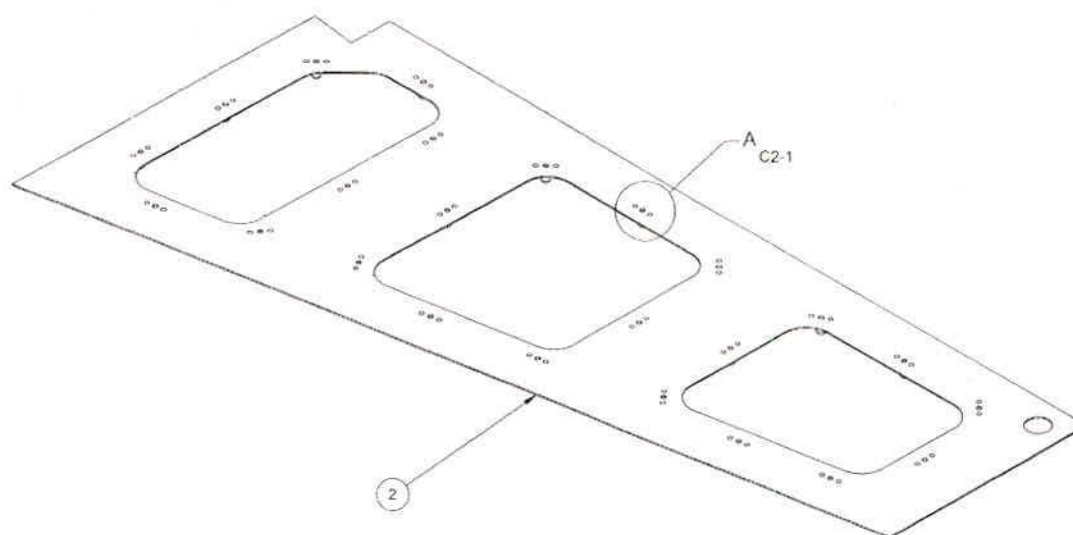
GA 60
121287 60
ST278 24
121236 24

121578 (15.4)
M12/01/07 (48)
12-5-07
12/05/07
24



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4463-041	TANK TOP ASSEMBLY
2	1	D4463-1	TANK TOP
3	48	MS20426AD3-4	RIVET
4	24	NAS1473R3	ANCHOR NUT

83529



DETAIL A
C4-1

D4463-041 TANK TOP ASSEMBLY

RELEASE
R 2012-04-24
MP

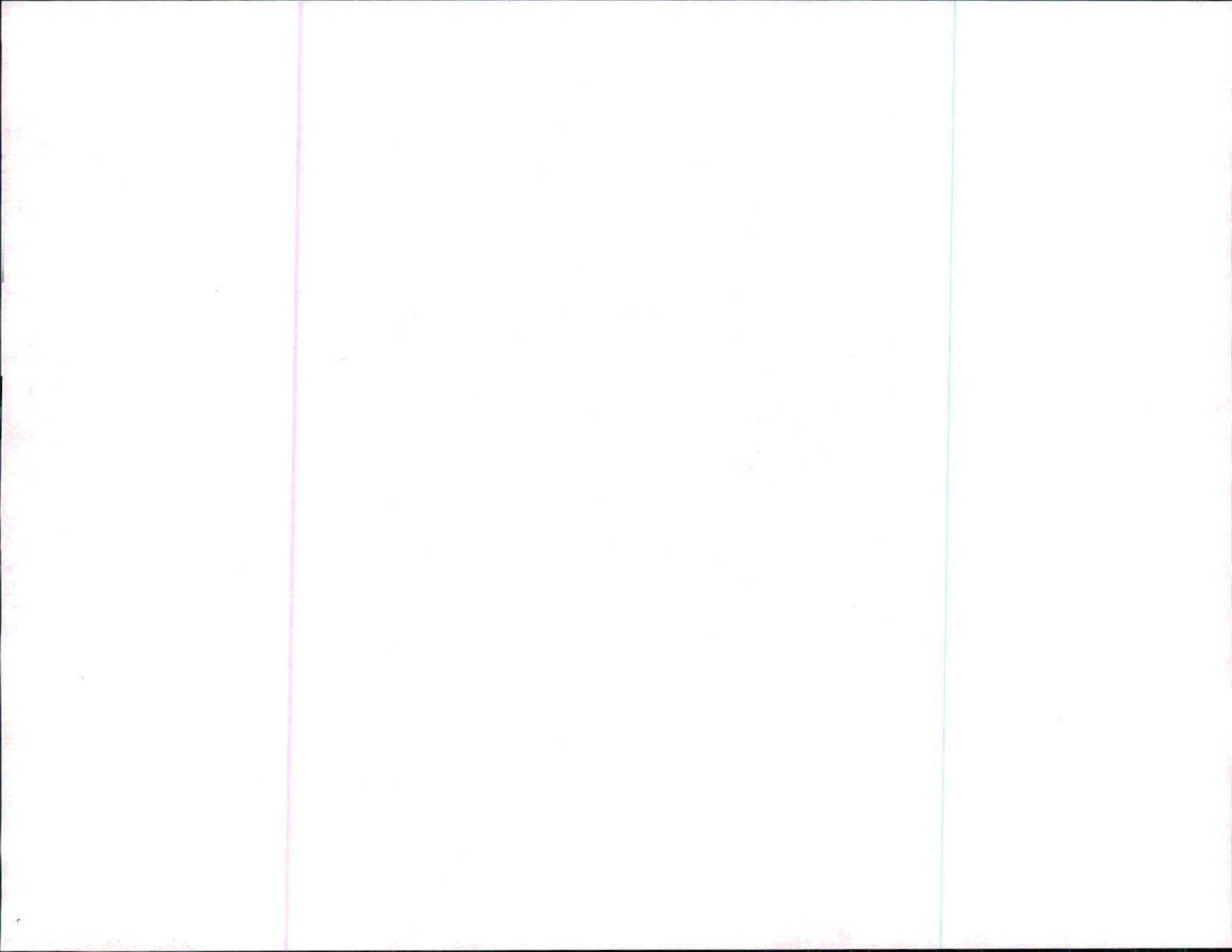
- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.76 lbs.

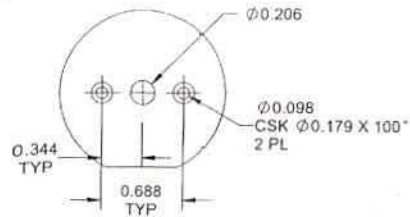
C	ADD DIMS: ZN B5-5, D5-5, B2-11, B7-11, D3-11 ADD -13, MODIFY -11-11	DC	12.03.23
B	ADD D4463-041, ZN C5-1 UPDATED -11/3/5/7-9, COMBINED -11 & -13 INTO -11	DC	11.12.14
A	NEW ISSUE	DC	11.10.19
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROV.			
DE APPR.			
DATE	12.03.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

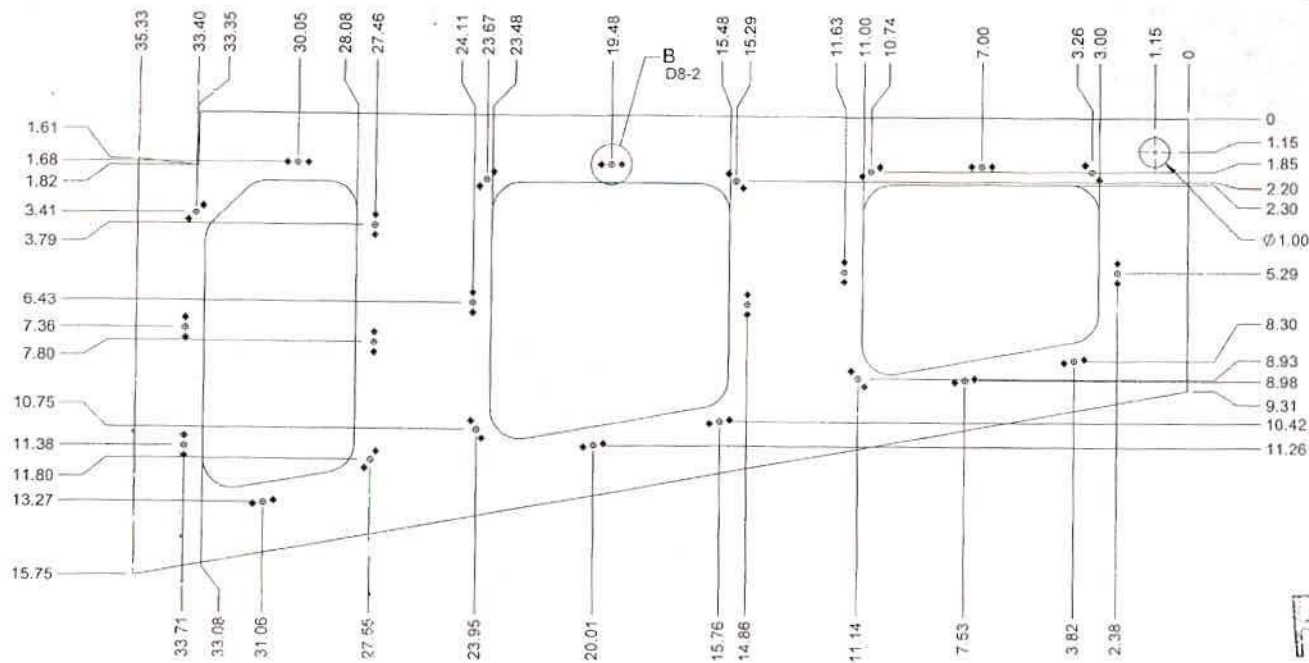
DRAWING NO. D4463 REV. C
SHEET 1 OF 14
TITLE TANK SCALE NTS

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DETAIL B
(24 PL)
C5-2



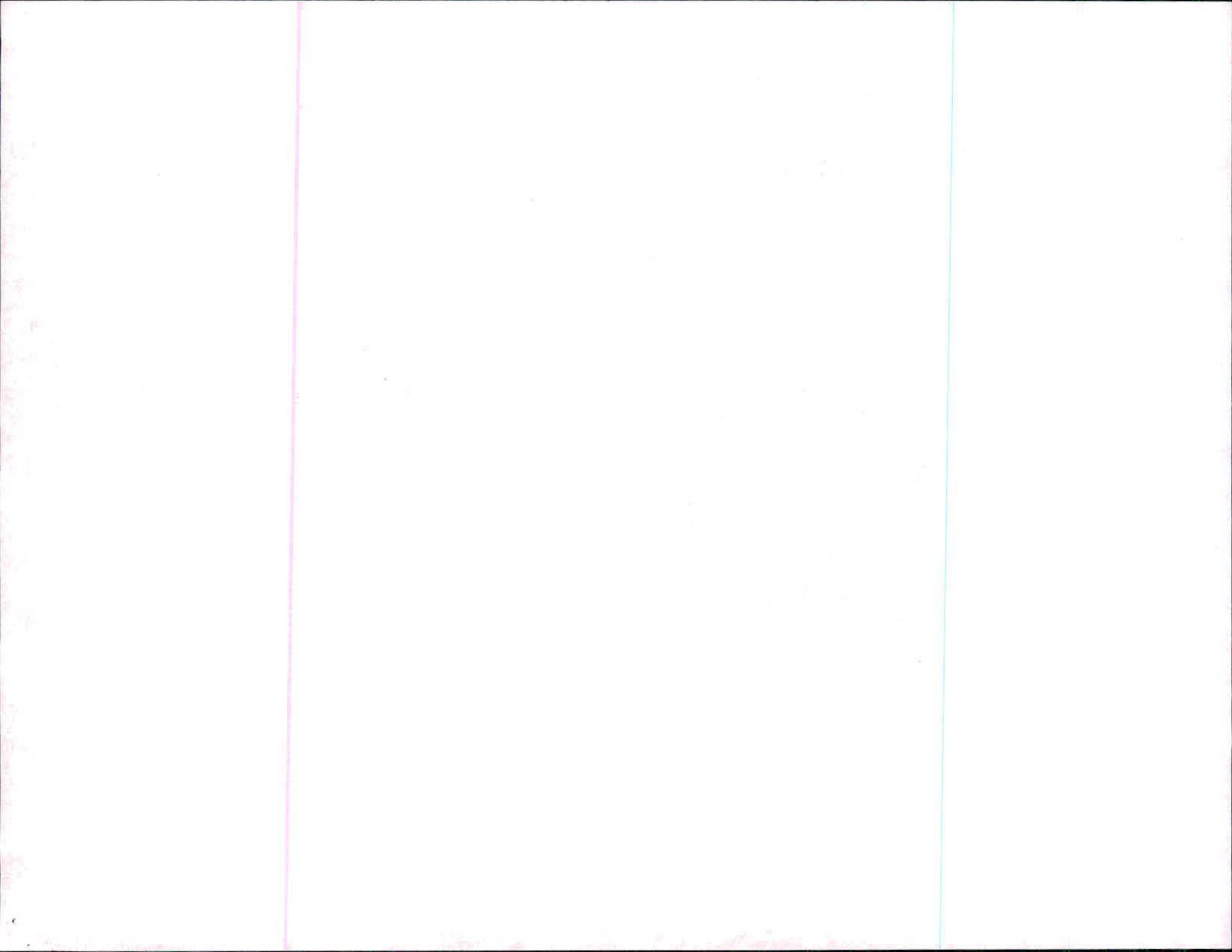
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHAPE EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.70 lbs



D4463-1 TANK TOP

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D4463	SHEET 2 OF 14
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TANK	N/A
DATE	12.03.23	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	



DART AEROSPACE LTD	Work Order: 83829
Description: Tank Top Assembly	Part Number: D4463-041
Inspection Dwg: D4463-1 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.93	+0.004 -0.001	0.100	✓		Vern	MB-02
0.206	+0.005 -0.001	0.208	✓		Vern	MB-02
1.00	+0.012 -0.001	0.999	✓		Vern	MB-02
1.15	±0.030	1.162	✓		Vern	MB-02
1.83	±0.030	1.856	✓		Vern	MB-02
2.06	±0.030	2.201	✓		Vern	MB-02
2.30	±0.030	2.315	✓		Vern	MB-02
5.24	±0.030	5.299	✓		Vern	MB-02
8.32	±0.030	8.317	✓		Vern	MB-02 Prod w/30
8.43	±0.030	8.934	✓		Vern	MB-02
8.43	±0.030	8.989	✓		Vern	MB-02
9.31	±0.030	9.314	✓		Vern	MB-02
10.41	±0.030	10.418	✓		Vern	Prod w/30
11.21	±0.030	11.253	✓		Vern	Prod w/30
1.61	±0.030	1.614	✓		Vern	MB-02
1.68	±0.030	1.681	✓		Vern	MB-02
1.82	±0.030	1.827	✓		Vern	MB-02
3.41	±0.030	3.416	✓		Vern	MB-02
3.79	±0.030	3.794	✓		Vern	MB-02
6.43	±0.030	6.433	✓		Vern	MB-02
7.36	±0.030	7.374	✓		Vern	MB-02
7.83	±0.030	7.866	✓		Vern	MB-02
10.51	±0.030	10.749	✓		Vern	MB-02

Measured by: <u>[Signature]</u>	Audited by: <u>[Signature]</u>	Prototype Approval:
Date: 12-5-1	Date: 7/6/03	Date:


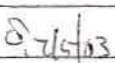
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	83929
Description: TANK TOP ASSEMBLY		Part Number:	D4463-04
Inspection Dwg: D4463-1 Rev: 1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.97	±.03	11.382	✓		vern	H13-02
11.26	±.03	11.808	✓		vern	H13-02
13.27	±.03	13.27	✓		MT	H13-01
1.15	±.03	1.153	✓		vern	H13-03
3.00	±.03	3.011	✓		vern	H13-02
3.26	±.03	3.265	✓		vern	H13-02
7.08	±.03	7.008	✓		vern	H13-02
10.74	±.03	10.758	✓		vern	H13-02 Prod-w-3-02
11.00	±.03	11.009	✓		vern	H13-02 Prod-w-3-02
11.63	±.03	11.635	✓		vern	Prod-w-3-02
15.29	±.03	15.29	✓		MT	H13-01
15.48	±.03	15.48	✓		MT	H13-01
19.48	±.03	19.48	✓		MT	H13-01
23.48	±.03	23.48	✓		MT	H13-01
23.67	±.03	23.67	✓		MT	H13-01
24.11	±.03	24.11	✓		MT	H13-01
27.46	±.03	27.46	✓		MT	H13-01
28.08	±.03	28.08	✓		MT	H13-01
30.05	±.03	30.05	✓		MT	H13-01
33.34	±.03	33.35	✓		MT	H13-01
33.40	±.03	33.40	✓		MT	H13-01
35.33	±.03	35.33	✓		MT	H13-01

Measured by: 	Audited by: 	Prototype Approval:
Date: 12-5-1	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD

Work Order: 93829

Description: TANK Top ASSEMBLY

Part Number: D4463-011

Inspection Dwg: D4463-1 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.38	±.01	2.382	✓		Vern	H13-02
3.82	±.01	3.832	✓		Vern	H13-02
7.53	±.01	7.545	✓		Vern	H13-02
11.14	±.01	11.155	✓		Vern	H13-02
14.96	±.01	14.96	✓		MT	H13-01
15.76	±.01	15.76	✓		MT	H13-01
20.01	±.01	20.01	✓		MT	H13-01
23.95	±.01	23.95	✓		MT	H13-01
27.55	±.01	27.55	✓		MT	H13-01
31.06	±.01	31.06	✓		MT	H13-01
33.08	±.01	33.08	✓		MT	H13-01
33.71	±.01	33.71	✓		MT	H13-01
0.062	±.001	0.062	✓		Vern	H13-02

Measured by:

KJ/JLM

Date:

12-5-1

Audited by:

J

Date:

17/5/03

Prototype Approval:

Date:

Rev

Date

Change

Revised by

Approved

A

New issue

KJ/JLM

